Page 1

July 14, 2009 10:31:41 AM

Item ID:

D2249-5

Е

Revision ID:

Gusset Item Name:

Start Date:

7/15/09

QC:

Start Qty: 5.00 10 12

Req'd Qty: 5.00 Required Date: 7/15/09



Accept

Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: **Tooling:**

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/ **Work Center ID**

Operation Description Set Up/ **Run Hours** Draw Number

Draw Rev.

Accept Qty Code

Reject **Qty**

Reject Number

Stamp

Draw Nbr **Revision Nbr** D2249 Rev E

Shear

Shear

SHEAR

Memo

Cut blank: 1.000" x 1.600"

0.00

0.00

Plan

110

Small Fab

Small Fab

Small Fab

Memo

Deburr any rough edges

0.00

0.00

120

QC5- Inspect part completeness to step on W/O

Memo

0.00

502/07/15

QC

Quality Control

Dart	Aeros	pace	Ltd
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W/O:		WORK ORDER CHA	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				•				
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	\:	_ Date: _		

Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		TED Description of NC		Corrective Action Section B		Varification					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			

Work Order ID 50237

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July 14, 2009 10:31:41 AM



Page 2

Item ID:

D2249-5

Accept

Setup Start

Stop



Revision ID: Item Name:

Start Date:

Gusset

Required Date: 7/15/09

7/15/09

Start Qty: 5.00

Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Draw

Rev.

Run Start

Stop



QC:

Date:

SPC (Y/N):

Date:

Plan

Code

Accept

Qty

Reject Qty

Reject Insp. Number Stamp

Work Center ID

130

Sequence ID/

Packaging

Packaging

140

Quality Control

Operation Description

Identify as per dwg & Stock Location

Set Up/ **Run Hours** 0.00

0.00

Draw

Number

0.00

Memo

Memo

QC21- Final Inspection - Work Order Release

0.00

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHAN	GES		****			
DATE	STEP	PRO	OCEDURE CHA	NGE	Б	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	o DQ ,	A :	_ Date: _	
		esolution:								
NCR:			WORK ORD	ER NON-CONFORM	MANCE (NCR)				
DATE	STEP	Description of NC	Corrective Action Section B			Veriti			Approvai	
	OIL.	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector
							:			
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	1		1				1			I

Picklist Print

July 14, 2009 10:31:41 AM

Work Order ID: 50237

Parent Item:

Comments:

D2249-5RevE

Parent Item Name: Gusset



Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M304S16GA		Purchased	No			100	sf	117.5511	0.1215	·		

304/316 Sheet .063

<u>Warehouse</u>	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	117.5510527	
106860	17	
111323	2.21	
111924	98.3410527	

Dart Aerospace Ltd

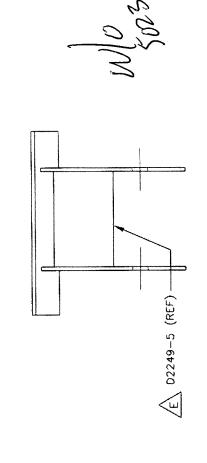
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W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		PAR #:											
_	R	esolution:	Dispositio	າ:	QA: N/C	Closed: _		Date: _					
NCR:		,	WORK ORDI	ER NON-CONFORMA	NCE (NC	R)							
		Description of NC		Corrective Action Section	on B	Vorif	ication	Approval	Approval				
DATE	STEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	l& ∣ _{Sec}	tion C	Chief Eng	QC inspector				
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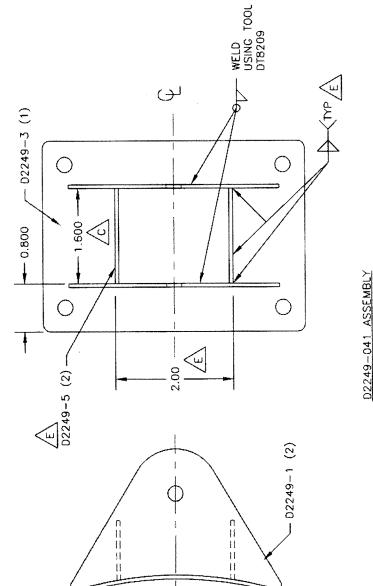


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1	DATE		TITLE	SCALE
	99.0	9.20	FITTING	NTS
	Α	94.06.20	NEW ISSUE	
	В	95.11.30	DIMENSION CHANGE	
	С	95.12.14	DIMENSION CHANGE	
	D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
	F	99 09 20	ADDED GUSSET	





MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

REV. E SHEET 1 OF 4

Dart Aerospace Ltd

W/O:			WORK ORDER	By Date Qty Approval Chief Eng / Prod Mgr					
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Chief Eng /	Approval QC Inspector
		_							
Part No	:	PAR #:	Fault Category:	NCR	l: Yes	No DQ	A:	Date:	<u> </u>
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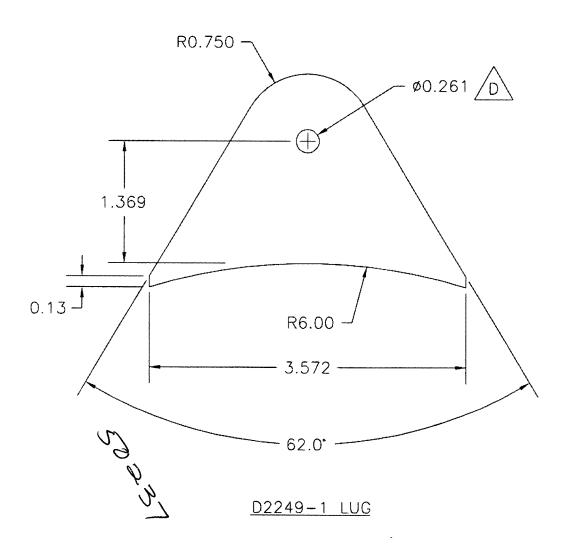
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
D.4		Description of NC		Corrective Action Section E	3	Verification					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC inspector			
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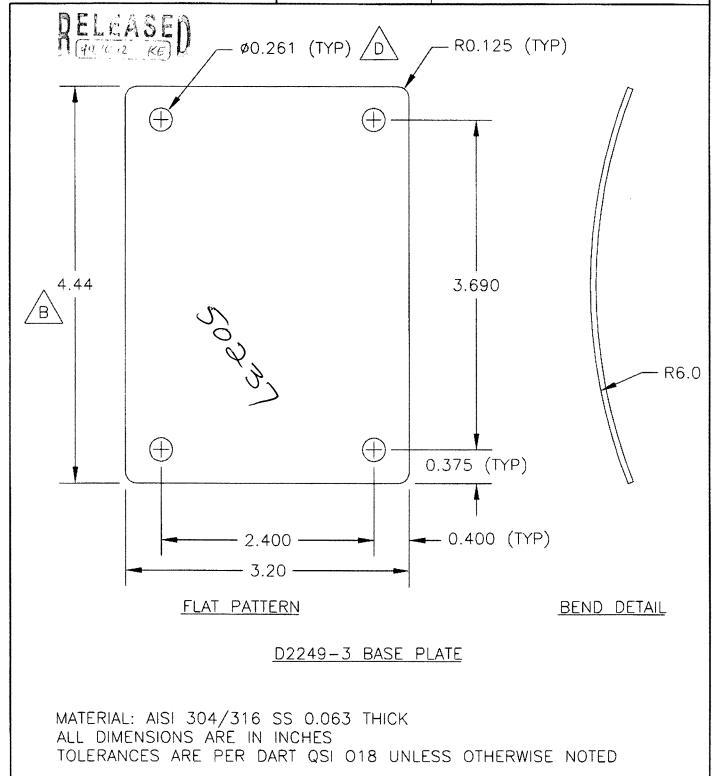
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DATE STEP		WORK ORDER CHANGES PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _		
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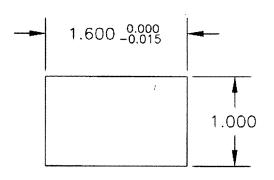
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DATE	STEP	Description of NC	Corrective Action Sec			Verification	n Approval	Approval			
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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Sold of the state of the state

D2249-5 GUSSET

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